

Work Order ID 84624

84624

Page 1

May-17-12 11:47:06 AM

Item ID: D044-715-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3243	Rev A								
IIN-D044-715	Rev A								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD044-715-011		CHG003						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

MLJ 12/05/13

JB

50

3

12/05/29 JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D044-715-011

Location: 42

140

0.00

140

QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

30 12/07/13 (B)

MLJ 12/07/13

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Picklist Print

May-17-12 11:47:10 AM

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Work Order ID: 84624

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Parent Item: D044-715-011

D044-715-011

Parent Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A04.02.18New issueKJ/JLM

IPP Rev:B 06-04-28 Manufactured on Water Jet JLM

IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC IPP Rev:D

11.05.04 remove FE-032-EF DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3243-041

Manufactured

No

110

Each

3.0000

D3243-041

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST227

3

76859

3

D1048

Manufactured

No

110

Each

58.0000

D1048

Saddle

**

Location

Loc Qty

Loc Code

GA

58

71872

2

76951

56

D1049

Manufactured

No

110

Each

20.0000

D1049

Saddle

**

Location

Loc Qty

Loc Code

GA

20

79033

20

D2010-104

Manufactured

No

110

Each

4.0000

D2010-104

Mirror Arm 369/500

**

Location

Loc Qty

Loc Code

ST220

4

74717

4

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Parent Item: D044-715-011

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Parent Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 3.00

Required Qty: 3.00

D2011-101

Manufactured No

110 Each

36.0000



3

D2011-101

6" Mirror

**

Location

Loc Qty

Loc Code

ST226

36

79943

36

79943

AN3-4A

Purchased No

110 Each

678.0000



12

AN3-4A

Bolt

**

Location

Loc Qty

Loc Code

ST350

678

102832

88

104291

4

104625

208

117317

98

120308

80

120770

200

104625

AN526C1032R10

Purchased No

110 Each

203.0000



12

AN526C1032R10

Screw

**

Location

Loc Qty

Loc Code

FP002

71

108062

71

ST348

132

110049

32

114494

100

110049

May-17-12 11:47:10 AM

Shop Packet Print

Page 2

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Parent Item Name: R44 Cargo Mirror, 6 inch Round

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 3.00

Required Qty: 3.00

ALS4-1032-130

Purchased

No

110

Each

3,287.000



12

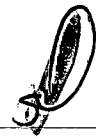


ALS4-1032-130

Insert

**

JB



Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

174

120807

36

120837

138

ST282

2908

121269

2908

AN960JD10L

NAS1149D0332J

Purchased

No

110

Each

0.0000



12



AN960JD10L

Washer

**

121269

121011

JB

12/05/29

May-17-12 11:47:10 AM

Shop Packet Print

Page 3

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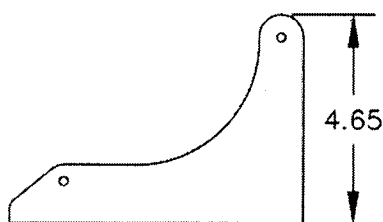
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09	TITLE BRACKET		SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 ± 0.030
0.000

NO WORK ORDER
84624 MCT
12/05/17
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

11.920
11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

0.500

0.000

GRAIN
DIRECTION

8.581

8.206

7.706

4.214

R0.25 (TYP)

3.339

R0.38
(TYP)

5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

6.560

5.810

5.360

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
04.02.03

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32.2 CARGO MIRROR REMOVAL

- 32.2.1 Remove the AN3 bolts securing the D3243-041 Bracket to the skidtube and remove the Cargo Mirror.
- 32.2.2 Reinstall the AN3-4A bolts in the inserts. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-715-011 Cargo Mirror Installation	1.3 lb 0.59 kg	41.7 in 1.06 m	54.2 lb-kgr 0.63 m-kgr	32.0 in 0.81 m	41.6 in-lb 0.48 m-kgr

32.4 PARTS LIST

Qty	Part Number	Description
X	D044-715-011	CARGO MIRROR INSTALLATION
2	D1048	Clamp
2	D1049	Saddle
1	D2010-104	Arm
1	D2011-101	Mirror
1	*D3014-1	Locknut
1	D3243-041	Bracket
4	ALS7-1032-130	Insert (or AKS7-1032-130, AKS4-1032-130, ALS4-1032-130)
4	AN3-4A	Bolt
4	AN526C1032R10	Screw (or AN526-1032R10)
4	AN960JD10L	Washers
1	*AN960JD416L	Washer

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

TC Accepted

MAR 31 2004

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